

Date: Wednesday, 03/09/2008 8:51:51 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
<b>Job Number</b> : 41703	
<b>Estimate Number</b> : 10530	
<b>P.O. Number</b> :	<b>Part Number</b> : D2571
<b>This Issue</b> : 03/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2571 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 03/09/2008 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 41587	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/09/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.9.03</u>	
<b>Comment</b> : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: B34875

*JS 08/09/21 + 2 billet for replace scrap.*

*JLD 08/09/19*

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 41703 Double check by: DSP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

*JLD / JS 08/09/20*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

*JLD JS 08/09/20*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--


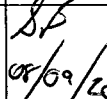

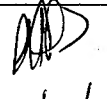



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*JLD JS 08/09/20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/09/25  
 Resolution: Scrap Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 08/09/25

NCR: <u>41703</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/20	2.0	2 part lift on facing operation on the Y axis.  RC Tooling	 08/09/22	Scrap and Destroy and replace Qty <u>82</u> B: 34875	 08/09/20	 08/09/22	 08/09/22	 08/09/22

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 8:51:51 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 41703

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/09/22

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/09/22

(10X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00  
320°F  
2:30

M-L

08/09/23

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-23 (X10)

MS

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 432

JS 08/09/24

(X10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/24

Job Completion



U 08.09.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 41703
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.260	.259	.259	.258		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.499	.497	.497	.497		
J	1.174	1.184		1.180	1.179	1.179	1.178		
K	0.558	0.578		.566	.564	.564	.568		
L	1.174	1.184		1.180	1.179	1.177	1.178		
M	1.490	1.500		1.493	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.874	3.873	3.873		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.252	.252	.252		
S	0.115	0.135		.135	.131	.133	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.239	.237	.237	.237		
W	0.115	0.135		.128	.127	.127	.127		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.761	.760		
Z	0.352	0.372		.356	.355	.358	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.617	.618	.619	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.252	.252	.252		
AE	1.375	1.395		1.387	1.389	1.388	1.385		
AF	0.115	0.135		.131	.131	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.251	.250	.250		
AI	2.000	2.020		2.000	2.004	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>MR 188</i>
Date: 01/09/20

Audited by: <i>J.L</i>
Date: 08/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41703	
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571	
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.563	.563	.563	.563		
L	1.174	1.184		1.179	1.179	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.875		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.127	.127	.126	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>JS</i>
Date: 08/09/21

Audited by: <i>JL</i>
Date: 08/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 41703
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.441				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.000				
F	0.490	0.510		.495	.495				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.875	3.875				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.185	.185				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.125	.125				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.250	.250				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									






Measured by: <i>SP</i>
Date: 08/09/22

Audited by: <i>SL</i>
Date: 08/09/22


Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SP</i>

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |

 $\triangle E$ 

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED #		APPROVED #
DATE 05.07.13		 DRAWING NO. D2571  TITLE OUTER FWD SADDLE
		DART AEROSPACE LTD. HAMBURG, ONTARIO, CANADA  REV. E SHEET 1 OF 1 SCALE 2:3

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DETAIL C  
SCALE 4:3

SHIP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4703